

Date: Monday, 7/31/2006 12:49:02 PM
 User: Chantal Lavoie

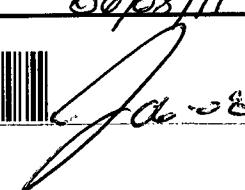
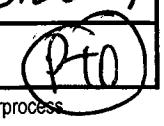
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CAP	
Job Number	: 28041		Part Number	: D2646	
Estimate Number	: 10312		Drawing Number	: D2646 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 7/31/2006	S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 8/15/2006	
Previous Run	: 25381		Qty:	100	Um: Each
Written By					
Checked & Approved By					
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>1759</u> 1-Spin as per Dwg D2646 2-Material release note required <i>CD 06/08/01</i> 
2.0	D2646P	Aft Cap
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) AFT CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <i>SL 06/08/11</i> 
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646 <i>Ja - 08-14</i> 
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .250" and c'sink as per Dwg D2646. 3-Deburr <i>FF 06.08.24</i> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-31	S-O	During c'sinking for NAS 1330C → 3K Dill inserts, the hole became oversized by .030 → .040. NAS insert was loose in the holes. Human error, risky c'sink on such thin, round material.	<i>[Signature]</i>	Drill hole open to .297, and debur as necessary. Insert 2x ALS4-1032-130 inserts AS per Dwg 2646 Rev. A.	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31
06-08-31	S.	1 part scrap. Used for insert test fit & strength.	<i>[Signature]</i>	The insert passed, but the cap is not good. Destroy.	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31	<i>[Signature]</i> 06-08-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: *[Signature]* Date: 06/08/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 7/31/2006 12:49:02 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 28041

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.m

06-09-01

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.m 06-09-01

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/08/02

9.0 ~~NAS1330C9KB116~~

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: ~~ALS4-1032-130~~

check inv.

Qty Part Number Description Batch
2 ~~NAS1330C9KB116~~ Insert ~~M19393~~

or ~~AE5510KB116~~

DL 06/09/03

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

DL 06/08/03 (1)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06-09-03 (1)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

DL 06/09/05 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 7/31/2006 12:49:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 28041

Part Number: D2646

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

100
04/09/05

Job Completion



06-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

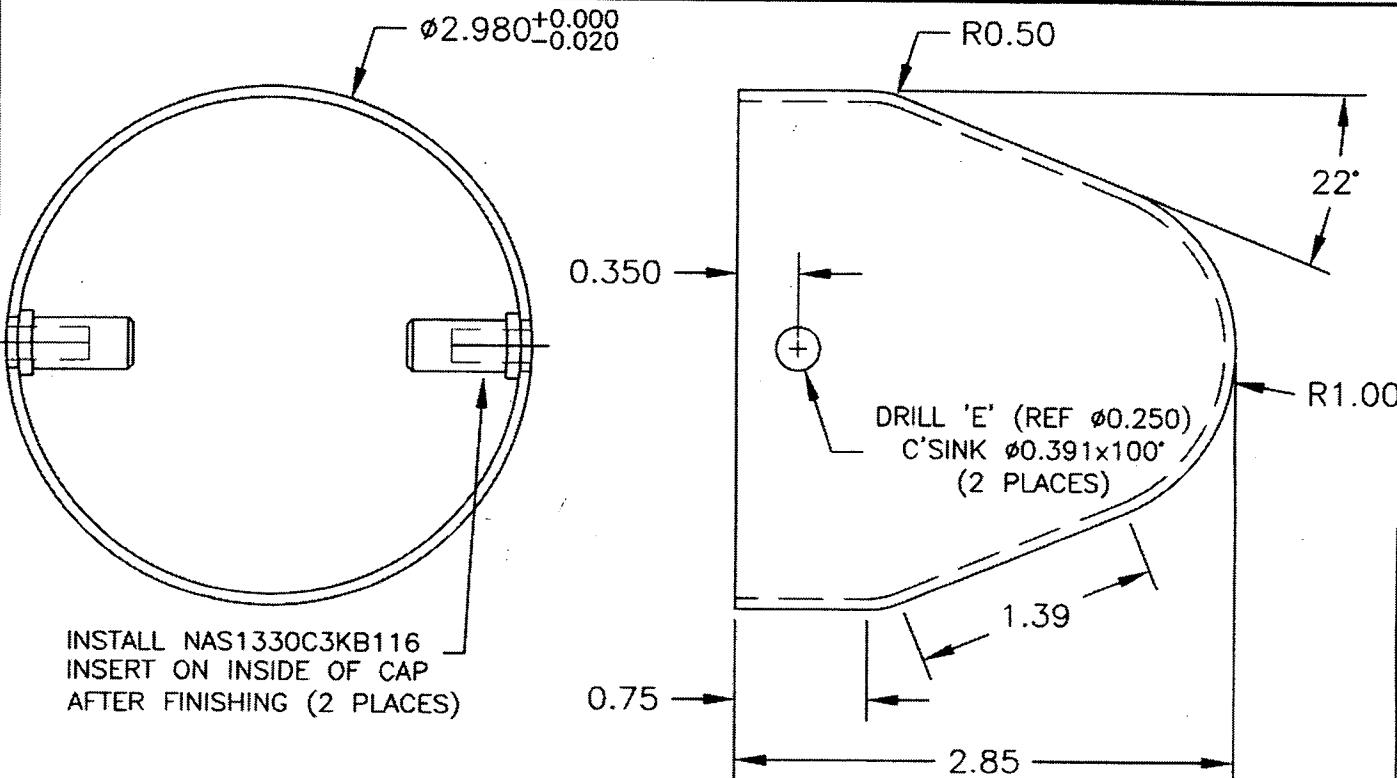
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2646
DATE		TITLE
05.04.01		AFT CAP
A	97.03.25	NEW ISSUE
B	05.04.01	CHANGE TO CLOSED INSERTS

REFERENCE ONLY**RELEASED**
05.08.09**D2646 AFT CAP**

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6238-205 Street, Langley, British Columbia, Canada, V2Y 1N7

INSPECTION REPORT

DATE: Aug 9 66

CUSTOMER: Dart AeroSpace

INVOICE #: 30484 SUPPLIER #:

DESCRIPTION OF INSPECTION:

NOTES OF INSPECTION: good

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

TEST CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH
ITEM NO	1	PART NO	050393-8			NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH NOT EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI

TAIL ULTIMATE STRENGTH 12.6 KSI

HEAD YIELD STRENGTH (OFFSET = .2t) 4.9 KSI

TAIL YIELD STRENGTH (OFFSET = .2t) 5.6 KSI

HEAD ELONGATION (G.L. = 2 IN) 35.5 %

TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, AMS 4001H 1100 O,

ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL

** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

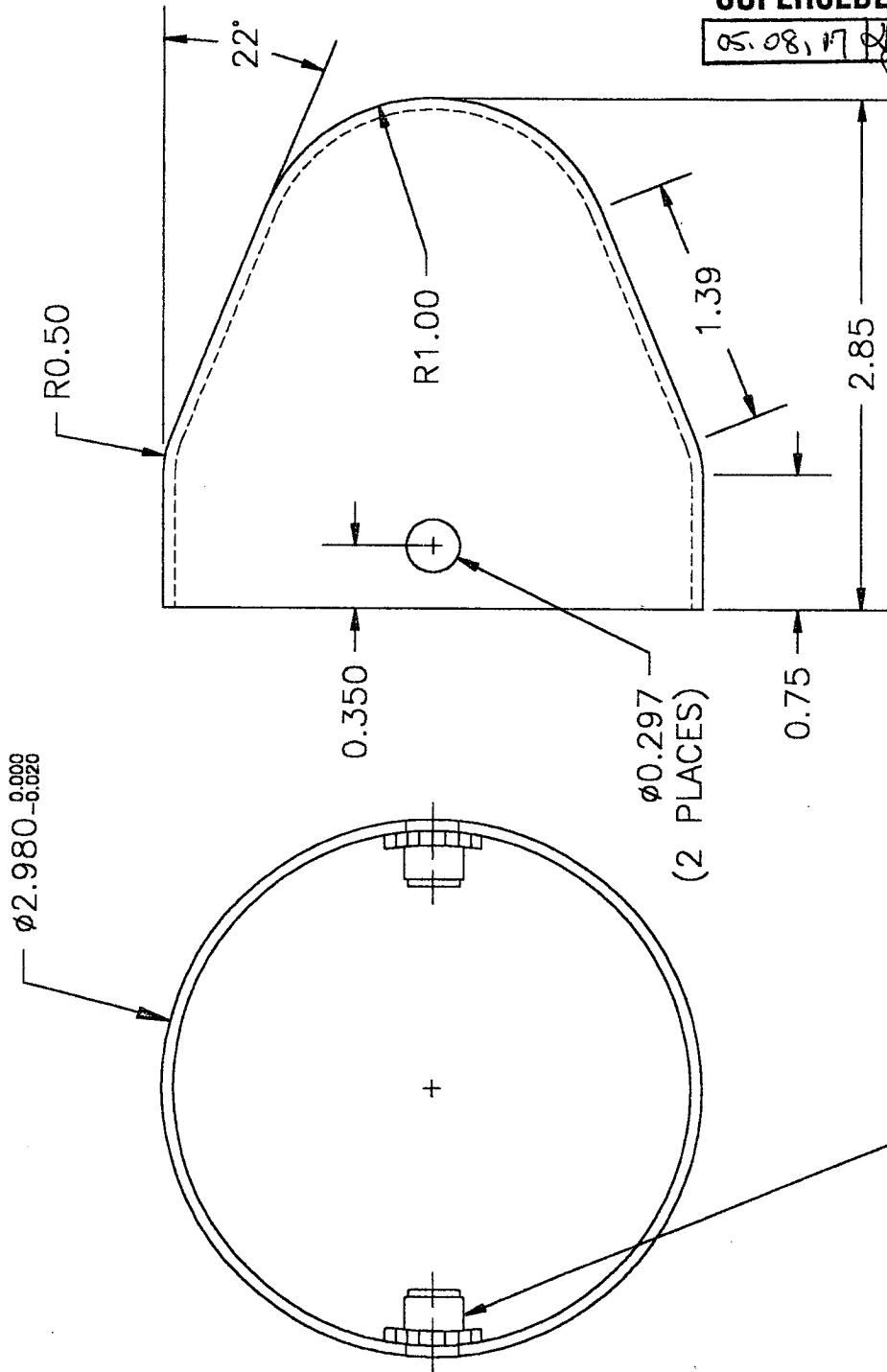
JEFF FREDDY, LAB SUPERVISOR

After
Sunny C. S. 9/9
C/S
Boyle
C/S



DARTA COPY IS
MADE
DATE

DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2646
DATE 97:03:25		REV. A SHEET 1 OF 1 SCALE 1:1



SUPERCEDED BY

05.08.17 DS

RELEASED
97/04/25 DS

INSTALL ALS4-1032-130 (OR AKS7-1032-130)
INSERT ON INSIDE OF CAP AFTER ALODINING
(2 PLACES)

MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
FINISH: ACID ETCH, ALODINE PER DART QST 005 4.1
TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED